

Date: Wednesday, 02/04/2008 11:27:42 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 38301	Part Number	: D3610041
Estimate Number	: 12812	Drawing Number	: D3610 REV.A
P.O. Number	:	Project Number	: N/A
This Issue	: 02/04/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: // Type : MACHINED PARTS	Due Date	: 14/04/2008 Qty: 12 Um: Each
Previous Run	: 38087		
Written By	:		
Checked & Approved By	: <u>JD 08.04.02</u>		
Comment	: est rev A new issue 07.03.28 EC		
	: est rev B released, changed mat'l EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140NB1500X15000	AISI 4140 Steel Bar
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Comment: Qty.: 0.5775 f(s)/Unit Total : 6.9300 f(s)

AISI 4140 Steel Bar

Batch N 106674

ml 08/04/08

(12)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blank 6.600 " long

Batch N 106674

ml 08/04/08

(12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA692 Rev: A & Dwg D3610 Rev: A

2-Deburr per dwg D3610

SA / B.A

08/04/09

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA / B.A

08/04/09

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IL 08/04/10

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:42 AM
User: Julie Lecocq

Process Sheet

30 ~~11/11~~
18/04/2008
S.060
#1 287-3
B238300
D.3610041
F
F
F
F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 38301

Part Number: D3610041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'SINK AS PER DWG D3610

FF 08-04-15

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/15 (12)

8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442

08-04-18

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/04/18

10.0 MS21075L3 Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
Nutplate
Batch: M10 7279

R

11.0 MS20426AD34 RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 24.0000 Each(s)
RIVET
batch: M10 5978

08/4/18 (12)

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Rivet Nut Plate as per Dwg D3610

FF 08-04-21

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/21 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:42 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 38301

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST244A

P-84/21 (12)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-21

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

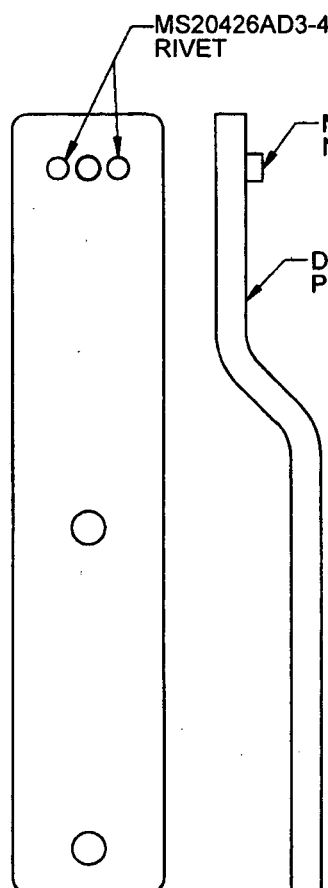
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

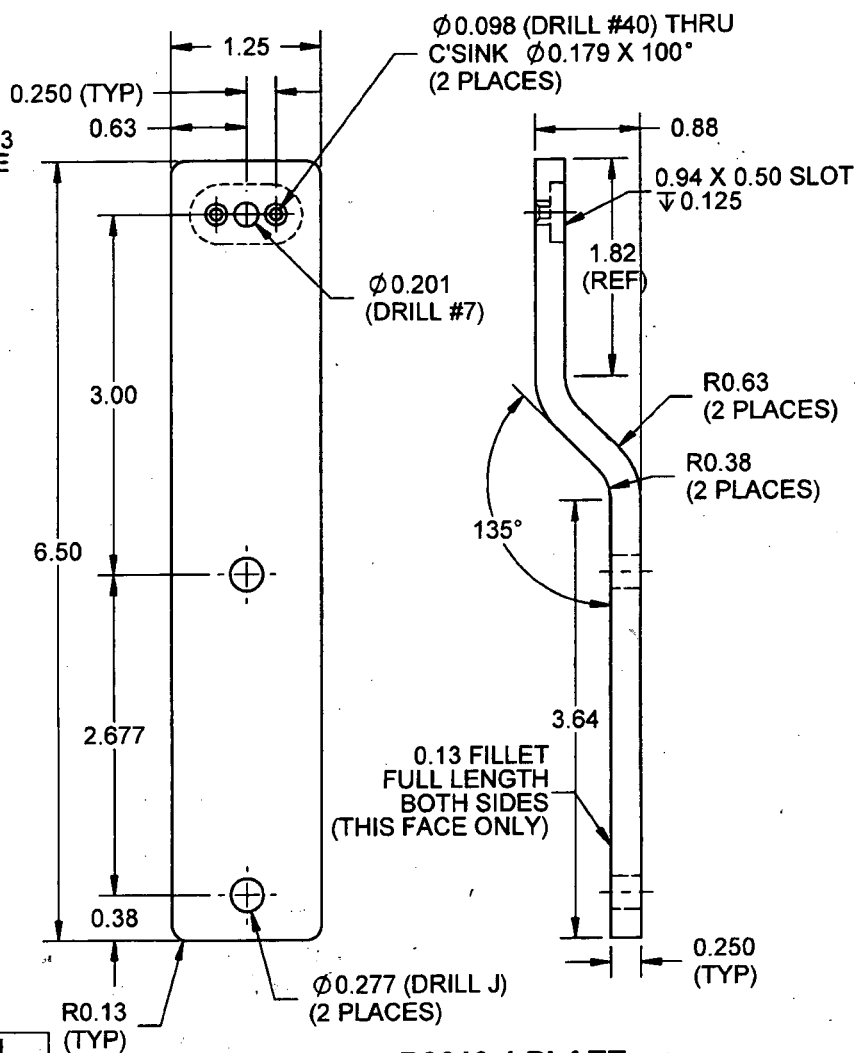
NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20	TITLE BRACKET		SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	



D3610-041 BRACKET



D3610-1 PLATE

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

RELEASED

07.04.25 *[Signature]*

D3610-041 NOTES:

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING

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WITHOUT NOTICE

WORK ORDER

NO. 38301

DART AEROSPACE LTD		Work Order:	58301
Description: <i>Plate</i>		Part Number:	153610-1
Inspection Dwg:	Rev: <i>A</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: <i>SA</i>	Audited by: <i>S.F</i>	Prototype Approval:
Date: <i>08/04/10</i>	Date: <i>08/04/10</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

P/O D3610-041